

Date: Monday, 1/14/2008 2:29:06 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	ARM		
Job Number	36715			Part Number	D2037101		
Estimate Number	10145			Drawing Number	D2037 REV C3		
P.O. Number	:			Project Number	N/A		
This Issue	1/14/2008	S.O. No.	:	Drawing Revision	C3		
Prsht Rev.	NC			Material	:		
First Issue	1/1	Type	SMALL /MED FAB	Due Date	1/31/2008	Qty:	5
Previous Run	36507			Um:	Each		
Written By	:						
Checked & Approved By	10/08.01.15						
Comment	Est Rev:A New Issue 05-11-01 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: MOTORS		
2.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE		
1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 2-Flatten ends of D2037-101 tube as required using DT8545 3-Deburr as required		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 51241A		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36715

Part Number: D2037101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

Dart 02/20

Job Completion



mi 2008/2/20

(5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

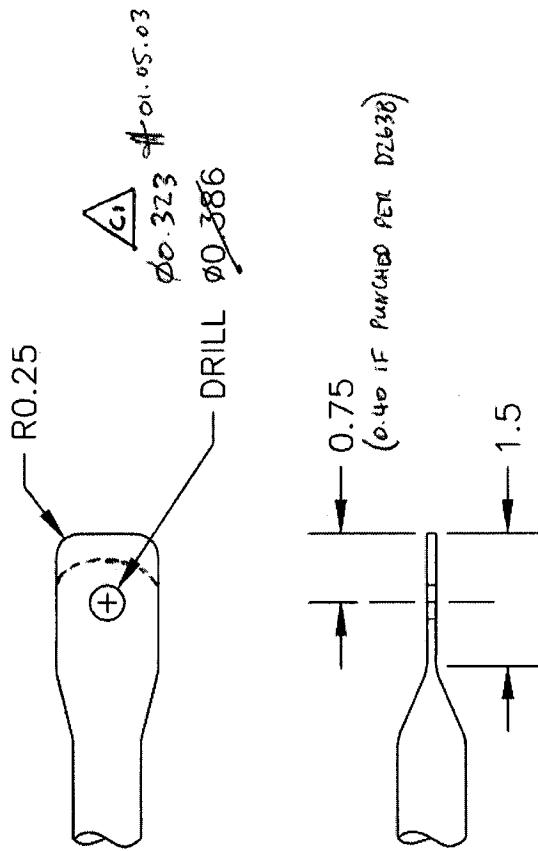
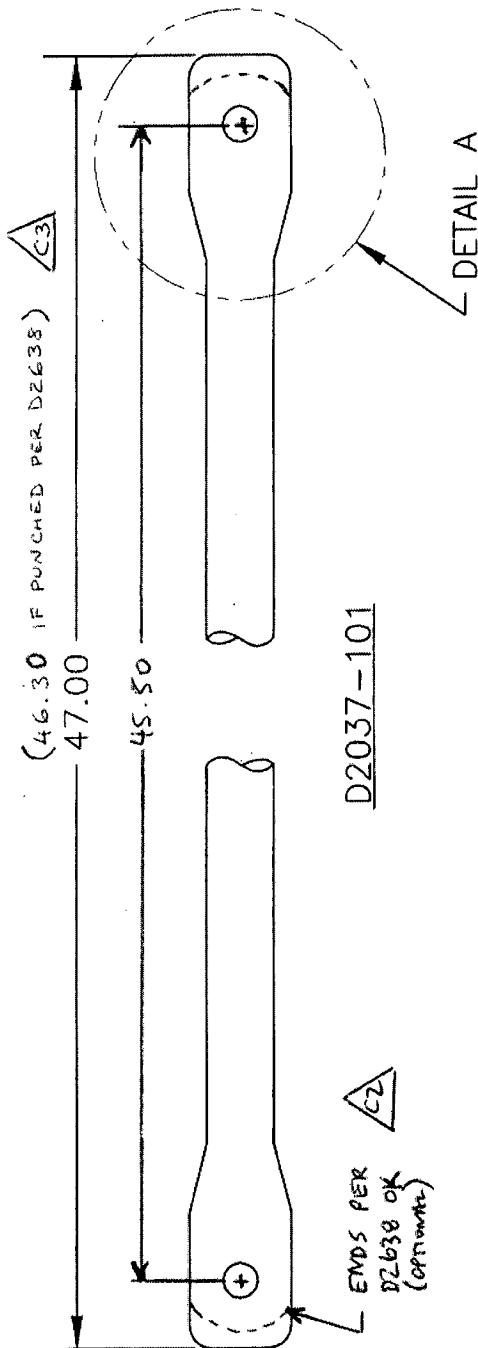
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTD4 COPY IS
Done

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED J	DRAWING NO. D2037
DATE 99.06.07		REV. C SHEET 1 OF 1
		SCALE NTS
A	91.10.22	NEW ISSUE
B	93.04.20	-103 DELETED
C	99.06.07	REDRAWN, 0.386 WAS 0.375
C1	if 01.05.03	CHANGE TO ϕ 0.323
C2	if 02.06.14	ADD PUNCH PER D2638 AS option



RELEASED
KE 19.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36715

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 ~~if~~ 05.04.27 ADD 46.30 PUNCHED PER D2638